Work Ord June-12-13 9:2		2988	_		Page 1						
Item ID: Revision ID: Item Name:	646.3715 Strut Doubler			Accept	*N900	040	100)* s	etup Stai	1/1	S1* S2*
Start Date: Required Date Reference:	6/11/13 : 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10 [*]		Cust Item l Customer:	ID:					
Approvals:		in: Mr2	Date: <u>13-66- (</u>	•		ate:	·	R	un Stai Sto	" \	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	rision Nbr	-	,							·
646.3700	A										
110				0.00							
110 Waterjet FLOW CNC Water	rjet	Memo 1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if i	A	0.00				10	0		<u>Ae</u> 13.07.18
*120 *120* QC		QC2- Inspect parts off m		0.00					. _o		<u>Ae</u> 13.07.18

Quality Control

DQA:	_	Date:							TAAC					
					WORK ORDER NON	-CC	ONFO	RMANCE / UPE				_		AEROSPACE
QA Closed:	·-·	Date:	.						\	Vork O	rder uş	odate only		
Work Orde	er:				DISPOSITION				AGAINST D	EPART	MENT,	/PROCESS		
				_	Rework	1		Skid-tube	Crosstube	7		Water Jet		Engineering
Part N	10.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	_	Quality
					Use-as-is		Therr	noforming	Finishing	R	ec/Sto	re/Packaging		Other
NCR N	10		·	_	Suspected Unapproved]		Large Fab	Composite [Supplier		\Box
Root		<u> </u>		Desci	ription of work order update		nitial	Actio	n	Sig	n &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	_	ate	Verification	ŀ	QC Inspector
Design													1	
Doc/Data													1	
Equip/Tooling														
Handling/Pre			1 1					1						:
Material			,				" v							
Operator														
Offset/Setup													-	
Process	Ц													
Supplier						ĺ								
Training														
Transport						1								
Unapproved			i		·									
						FAI	ULT CA	TEGORY						
Landi	ng Gear			_	General	_	1 .		-	_		_		
	Bending			_	Bend	╙	•	Program	_	⊣		ensions		ressure/Forced
•	_	Not Conce	ntric	<u> </u>	BOM/Route		Grain		_	- 1 '		tolerance		et-up
	Cracks				Broken/Damage/Defect	<u> </u>	Hardwa			→	ncorre	}	™	emperature/Cure
į		ink/Ripple	e/Wave	<u> </u>	Burrs		Inspect	ion Incomplete/Unqu	ualified	Part l	.ost/Mi	issing	┥.	/eld
!	Cuffs				Contamination	_	4	tions Incomplete/Und	clear	-	Moved	L	\	rong Stock Pulled
	Crushin	=			Countersink	L_	1 -	gned/off center		_	oned V			
	Heat Tre			<u> </u>	Cut Too Short		Mislabe			Powe	r Loss/	Surge	0	ther
		on Strip in	Tube	<u> </u>	Drawing	L	Misread							
İ	Marks/0				Drill Holes		Off-set							
	_	Sequence		_	Finish		-	Calibration						
	Wave/Twist in Tube				Fit/Function	<u>l</u>	Out of 9	Sequence		_				

Work Ord June-12-13 9:2	ler ID 10	2988	*1	02988*			Page 2	
Item ID: Revision ID: Item Name:	646.3715 Strut Doubler		Accept	*N900		n * s	Setup Start Stop	10'21
Start Date: Required Date Reference:	6/11/13 e: 6/11/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*	Cust Item II Customer:	D:			
Approvals:			Tooling:		ate:		Run Start Stop	"NR1"
Sequence ID/ Work Center I 130 *130* QC Quality Control	 ID	Operation Description QC8- Inspect parts - second check Memo	Set Up/ Run He 0.00	ours	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
140 *140* Outsource4 Outsource process	- Anodize	Outsource process-Anodize per QSI Memo Issue P/O to ATG 2 1- Black Anodize as pe	0.00 0078 r Dwg 646.3700					13-07-24
150 *150* Packaging Packaging		2- PRIME AS PER DW Certification of Comfor Receive & Inspect for Damage & M . Memo	mity is required			<u>[0 X</u>	. 	SP

DQA:			Date:			- ``` ` ` ` \ \ \ \ \ \ \ \ \ \								TAACT
OA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE	147	ork Order up	adata anlız - F	AEROSPACE
QA Closed:	_		Date.			<u> </u>				 ,	VV	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
						Rework]		Skid-tube	Crosstube	Γ_]	Water Jet	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	-	Pro	d. Eng. Coor.	Quality
	•					Use-as-is			noforming	Finishing		1	re/Packaging	Other
NCR I	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	
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Root	Ì				Desci	ription of work order update		Initial		tion		Sign &		+
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Handling/Pre								٠.						
Material -					j			4.5						
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Process									!					
Supplier Training				•	1									
Transport														
Unapproved			 	İ										
опарриотеа		L	1		<u> </u>		FA	ULT CAT	rEGORY		_	L	l	
Landi	ng (Gear				General				_				
1		Bending				Bend		Folio/P	rogram .			Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	Г	Grain				Over/Under	tolerance	Set-up
!		Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Ur	nqualified		Part Lost/Mi	issing	Weld
		-			Contamination		Instruct	ions Incomplete/l	Unclear		Part Moved	_	Wrong Stock Pulled	
		Crushing		-		Countersink		Misalig	ned/off center			Positioned V	Vrong	<u> </u>
		Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other
	Inspection Strip in Tube Drawing					Drawing		Misread	i					
	Marks/Chatter Drill Holes				4		Off-set							
		Turning S				Finish	_	4	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function	<u> </u>	Out of S	Sequence					

Work Order ID June-12-13 9:23:49 AM	102988			Page 3			
Item ID: 646.3715 Revision ID: Item Name: Strut Dou Start Date: 6/11/13 Required Date: 6/11/13 Reference:		*10* *10*	Accept	*N90004010 Cust Item ID: Customer:	()* Setu	start Stop	*NS1* *NS2*
	Plan:	Date:		Date:Date:	Run -	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID 160 *160* QC Quality Control	Operation Description QC5- Inspect part comple	eteness to step on W/O	Set Up/ Run Houl-7 0.00	Tool ID Tool # Plan Code	•		Reject Insp. Number Stamp
190 *100* Packaging Packaging	Identify as per dwg & Sto Memo ***IDENTII REV***	ock Location: 875	0.00 0.00 -120 BY STAMPING 1	THE P# AND	lox.		13-8-2
200 *200* QC Quality Control	QC21- Final Inspection - Memo	Work Order Release	0.00		M <i>C</i>	2 73	100 821 100 821

М.,

f10.08.31

DQA:		_ Date:											-	TOAC
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPE		W	ork Order up	odate only	· 	AEROSPACE
Q/ Closed.		- Dute:												
Work Orde	er:				DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
					Rework			Skid-tube	Crosstube]	Water Jet	٦ E	ngineering
Part N	ło		•		Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
					Use-as-is		Thern	noforming	Finishing		Rec/Sto	re/Packaging	_	Other
NCR N	10				Suspected Unapproved	•		Large Fab	Composite [J	Supplier		ا لـا
Root		1		Desc	ription of work order update	ا	Initial	Action	n		Sign &	 		· · · · · · · · · · · · · · · · · · ·
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion		Date	Verification		QC Inspector
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Doc/Data	_													in the second se
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Handling/Pre														
Material	- -													
Operator	\dashv													
Offset/Setup Process			}											
Supplier	\dashv				;									
Training														
Transport			}											
Unapproved				1										
				٠.		FAI	ULT CAT	TEGORY		_				
Landii	ng Gear				General									
	Bending				Bend	Γ	Folio/F	rogram			Outside Dim	ensions	Pre	essure/Forced
	Centre N	lot Conce	ntric		BOM/Route		Grain		Ī	_	Over/Under	tolerance	Se	t-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	:t [Te	mperature/Cure
	Crimp/K	ink/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqu	ualified [Part Lost/Mi	ssing]w₀	eld
	Cuffs				Contamination		Instruct	ions Incomplete/Und	clear [Part Moved		$ w_i $	rong Stock Pulled
	Crushing	3			Countersink		Misalig	ned/off center			Positioned V	Vrong		
	Heat Tre	at			Cut Too Short		Mislabe	eled	[Power Loss/	Surge	Ot	her
	Inspection	on Strip in	Tube		Drawing	L	Misread	1						
	Marks/C	hatter			Drill Holes		Off-set							
i		Sequence		<u> </u>	Finish		4	Calibration						
	Wave/Twist in Tube				Fit/Function	<u> </u>	Out of 9	Sequence						

June-12-13 9:23:49 AM

Work Order ID:

102988

Parent Item:

646.3715

Parent Item Name:

Strut Doubler

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No		····	110	sf	660.5856	0.0434 —//7-	0.4568421 12635.C	<u> </u>		13.07.18
				Location		Loc Qty	Lo	e Code				Æ	13.07.18
44				MAT021		660,5856							
(2 ⁷				121 123	099 874	273.7156 386.87							

13.7.18

DQA:	Date:								•					TAACT	
						WORK ORDER NON-	-CONFORMANCE / UPDATE								
QA Closed:			Date:								W	ork Order up	date only		
Work Orde	er:					DISPOSITION									
	_					Rework	1		Skid-tube	Crosstube	Г]	Water Jet	Engineering	
Part N	۷o.					Scrap			Machining	Small Fab	_	Pro	d. Eng. Coor.	Quality	
	_	•			_	Use-as-is		Therr	noforming	Finishing		Rec/Stor	e/Packaging	Other	
NCR N	No					Suspected Unapproved]		Large Fab	Composite]	Supplier		
Root					Desc	I ription of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector	
Design													*		
Doc/Data														F 7	
Equip/Tooling												<u>[</u>		3.0	
Handling/Pre															
Material				ļ											
Operator	Щ	ı		٠.								!			
Offset/Setup	Ш	:				j									
Process		,													
Supplier												Ì			
Training	Ш					į						!			
Transport	Ш						1								
Unapproved	Ш			<u> </u>			<u> </u>					<u> </u>		<u> </u>	
							FA	ULT CA	TEGORY						
Landi	ng Ge	ar				General		,			_	٦	_	_	
	ЩB	ending			<u> </u>	Bend	<u> </u>	•	Program			Outside Dim	ensions	Pressure/Forced	
i	LJC	entre No	t Concer	ntric	-	BOM/Route	<u> </u>	Grain			<u></u>	Over/Under	tolerance	Set-up	
ļ	\vdash	racks			\vdash	Broken/Damage/Defect	<u> </u>	Hardwa	ire		\perp	Part Incorred	├	Temperature/Cure	
	Щ	rimp/Kin	k/Ripple	/Wave	<u> </u>	Burrs	_	Inspect	ion Incomplete/Un	nqualified	L	Part Lost/Mi	ssing	Weld	
		uffs			<u> </u>	Contamination	<u> </u>	1	tions Incomplete/U	Inclear	L	Part Moved	L	Wrong Stock Pulled	
	-	rushing			<u> </u>	Countersink	<u>_</u>	1	ned/off center		lacksquare	Positioned V			
!	-	leat Trea			<u> </u> _	Cut Too Short	_	Mislabe				Power Loss/	Surge	Other	
	_	nspection		Tube		Drawing		Misrea	t						
:	╚	/larks/Ch	atter			Drill Holes		Off-set							
		urning So			L	Finish		Out of	Calibration					<u> </u>	
	Wave/Twist in Tube			oe		Fit/Function	Out of Sequence								

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	102988
Description: Strut Doubler	Part Number:	646.3715
Inspection Dwg: 646.3700 Rev: A		Page 1 of 1

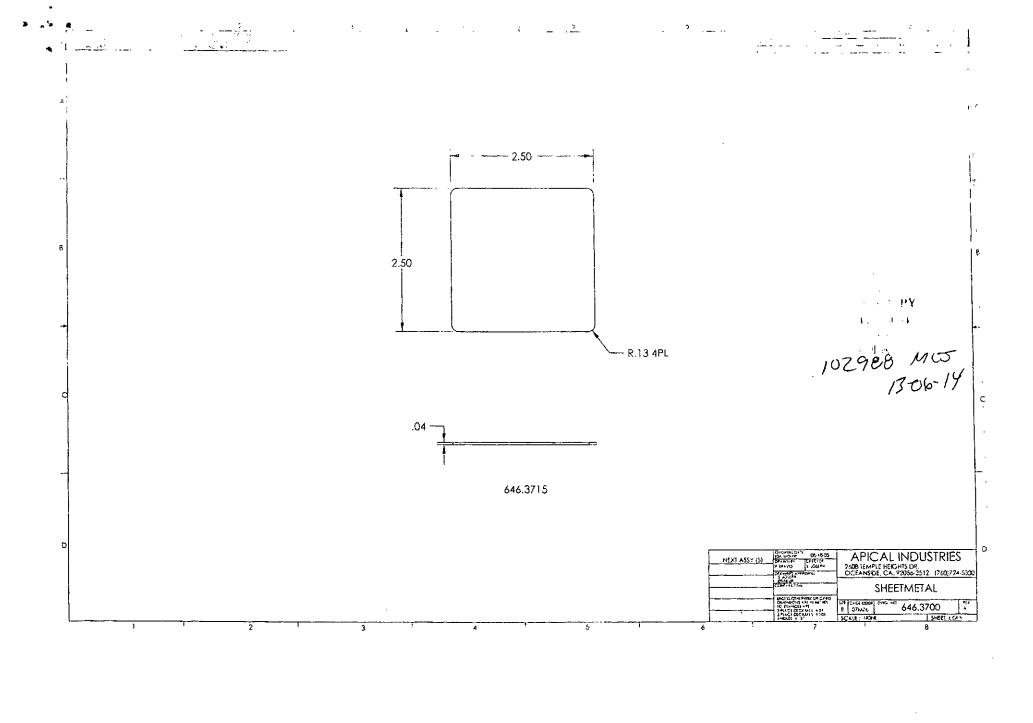
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.005	2.49	_		JKm	JKm-01
2.50	+/-0.005	249			~	
0.040	+/-0.005	038			V	
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sured by:	de T	Audited by:	27		Preliminary A	pproval:

			V		
Measured by:	Ae	Audited by:	27	Preliminary Approval:	
Date:	13.07.18	Date:	13718	Date:	
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Rev	Date	Change	Revised by	Approved
Α	13.03.04	New Issue	KJ 😽	18
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A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62574

Date: 20-Aug-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	-		
					
Quantity	Description				
1	Part: ASST		Rev:		
lot	_				
	6 PCS 646.3717 12 PCS 646.3719				
(20 PCS 646.3715)				
	10 PCS 646.3718 4 PCS 647.9312				
	30 PCS 647.9610				
	HARD ANODIZE BLACK				
	MIL-A-8625 TYPE III CLASS 2				
•	PRIME MIL-P-23377J TYPE I CLAS				
	Job: 20130523	PO: 20678	Line:		
	Certificate of Conf	ormance			
	A.T.G. Industries certifies that all items in	n this shipment are i	n conformance		
	with all requirements, specifications and	drawings referenced	I in the purchase order.		
	ISO 9001 : 2008 REG				
	ATG SALES-2010 TEI	RMS APPLY			
	DATE: 20/9/13				
	m				
	CERTIFIED SIGNATURE :		-	•	
	RECEIVER SIGNATURE :		-		
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pace Ltd. Adeen Street Jury, ON K6A 1K7 3 632 9577

OUTSTANDING PO REPRINT

Purchase Order ID PO20678

Purchase Order Date 7/24/2013 PO Print Date 8/20/2013

Page Number 2 of 4

/der From:

VC-ATG001

A.T.G. INDUSTRIES INC. 731 INDUSTRIELLE ROAD ROCKLAND, ON K4K 1T2 CANADA

Contact Name

Vendor Phone

613-446-4544

Vendor Fax

613-446-4556

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Vendor A	ccount Nbr		Terms Currency FOB	Net 3 CAD Desti			
Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID		Date/ xable	Req Qty	Unit Price	Extended Price
7	104679	646.3719 DOUBLER	8/2/2013 Yes	12.00	Ship Method	\$8.4780 Yours ppd	\$101.74
		Special Inst:	SAME AS ABOVE	į		e Total:	\$101.74
8	103610	646.3715 STRUT DOUBLER	8/2/2013 Yes	10.00	Ship Method	\$8.4780 Yours ppd	\$84.78
		Special Inst:	SAME AS ABOVE		Lin	e Total:	\$84.78
9	102988	646.3715 STRUT DOUBLER	8/2/2013 Yes	10.00	Ship Method	\$8.4780 Yours ppd	\$84.78
		Special Inst:	SAME AS ABOVE		Lir	ne Total:	\$84.78

